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Whereas the Parliament of India has set out to provide a practical regime of right to information for citizens to secure access to information under the control of public authorities, in order to promote transparency and accountability in the working of every public authority, and whereas the attached publication of the Bureau of Indian Standards is of particular interest to the public, particularly disadvantaged communities and those engaged in the pursuit of education and knowledge, the attached public safety standard is made available to promote the timely dissemination of this information in an accurate manner to the public.

**“जानने का अधिकार, जीने का अधिकार”**

Mazdoor Kisan Shakti Sangathan

**“The Right to Information, The Right to Live”**

**“पुराने को छोड़ नये के तरफ”**

Jawaharlal Nehru

**“Step Out From the Old to the New”**

IS 845 (1974): Swage Blocks and Stands [PGD 6: Earth, Metal And Wood Working Hand Tools]

**“ज्ञान से एक नये भारत का निर्माण”**

Satyanaaranay Gangaram Pitroda

**“Invent a New India Using Knowledge”**



**“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”**

Bhartṛhari—Nītiśatakam

**“Knowledge is such a treasure which cannot be stolen”**





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*Indian Standard*  
**SPECIFICATION FOR  
SWAGE BLOCKS AND STANDS**  
*(First Revision)*

- 1. Scope** — Lays down the requirements for swage blocks and stands.
- 2. Dimensions**
- 2.1 Swage Block** — See Fig. 1.
- 2.2 Swage Block Stand** — See Fig. 2.
- 2.3** Swage blocks and stands with slightly different dimensions may be accepted subject to prior agreement between the purchaser and the supplier.
- 3. Material** — Swage blocks shall be manufactured from cast iron conforming to Grade 20 of IS : 210-1970 'Specification for grey iron casting (second revision)' or from steel casting conforming to Grade 3 of IS : 1930-1962 'Specification for steel castings for general engineering purposes (revised)'.
- 4. Manufacture and Finish**
- 4.1 Blocks** — Blocks shall be sound castings, free from blow holes, scales and other defects. They shall be smoothly finished all over. The surface of holes, slots and sides shall be properly formed and reasonably smooth. The half circles and other shapes on the vertical edges shall be less than half the intended nominal dimension.
- 4.2 Stands** — Stands shall be of sound castings free from blow holes, scales and other casting defects.
- 5. Preservative Treatment and Packing** — The body of each swage block and stand shall be given an antirust treatment. Swage blocks and stands shall be securely packed in suitable packing cases of a size convenient for handling in transit or as specified by the purchaser.
- 6. Sampling** — Unless otherwise agreed to between the buyer and the seller, the procedure given in IS : 2500 (Part I)-1963 'Sampling inspection tables: Part I Inspection by attributes and by count of defects', shall be followed for sampling inspection. The sampling plans for various characteristics shall be according to **6.1** and **6.2**.

**6.1** For inspection of dimensions and manufacture and finish, single sampling plan with inspection level III and acceptable quality level (AQL) of 2.5 [see Tables 1 and 2 of IS : 2500 (Part I)-1963] shall be adopted.

**6.2** For inspection of material, single sampling plan with inspection level I and acceptable quality level (AQL) of 1.0 percent [see Tables 1 and 2 of IS : 2500 (Part I)-1963] shall be adopted.

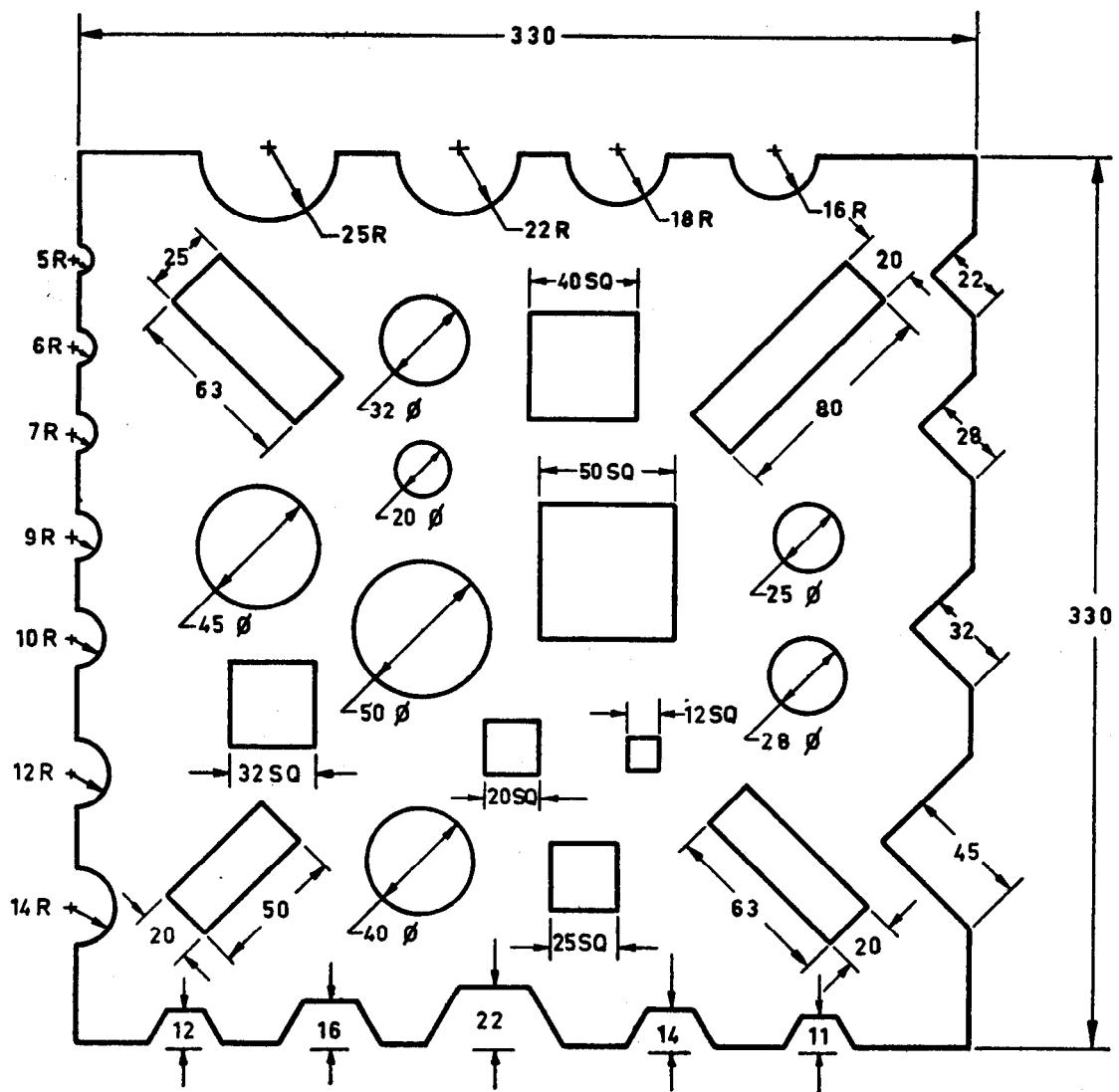
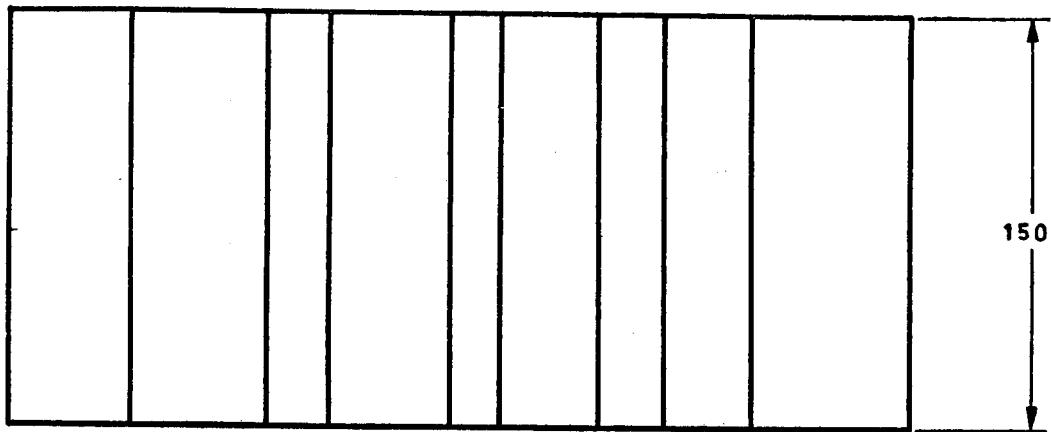
**7. Marking** — Each block and stand shall be clearly and legibly stamped or cast in embossed letters, with the supplier's name, initials and/or recognized trade-mark at a prominent place.

**7.1 ISI Certification Marking** — Details available with the Indian Standards Institution.

Adopted 30 January 1974

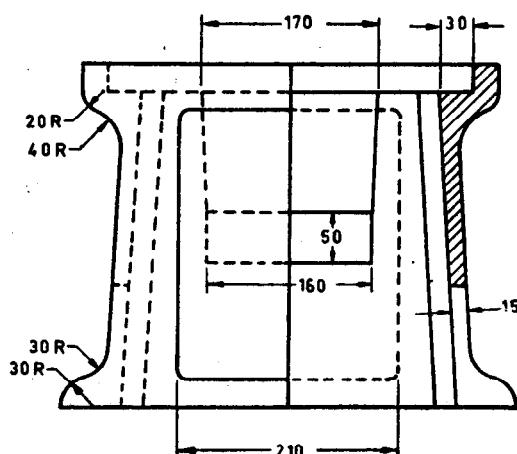
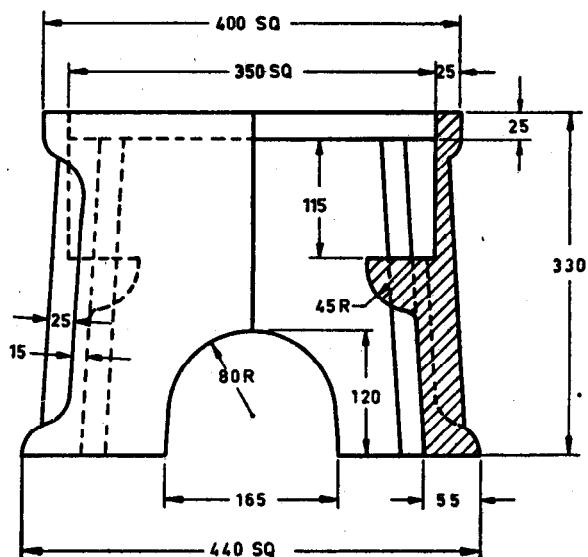
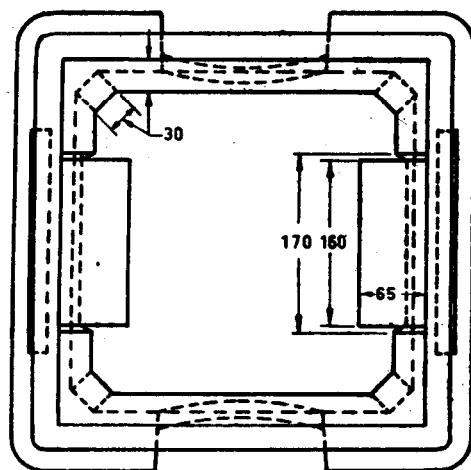
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All dimensions in millimetres.

**FIG. 1 DIMENSIONS FOR SWAGE BLOCK**



All dimensions in millimetres.

FIG. 2 DIMENSIONS FOR SWAGE BLOCK STAND

#### EXPLANATORY NOTE

This standard was first issued in 1961. The present revision has been taken up to bring the standard in line with the current manufacturing practices. Swage blocks are generally used for heading bolts and swaging bars. Swage blocks and stands are supplied together unless specified otherwise. It is, therefore, recommended that indents should specifically indicate their requirements in the enquiry and the order if they do not need the items together.